

Work Order ID 57137

March 23, 2010 1:13:26 PM



Page 1

Item ID: D205-634-041

Revision ID:

Accept



Setup Start



Item Name: Replacement Skidtube

Stop



Start Date: 23/03/2010 Start Qty: 1.00

Required Date: 09/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-3-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110



CNC Bend I

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

MS

10-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Date:

Stop

Sequence ID/
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NumberDraw
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QtyReject
QtyReject
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Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R ☐ ☐ Aluminum Rod

m113207

BE 10/03/31

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R ☐ ☐ Aluminum Rod

m113207

BE 10/03/31

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

- AWM 10-4-01

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Page 4

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Stamp

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

8.064106

Memo

0.00

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8.064106

Memo

0.00

(x1)

170



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd
cap out of solution.

BR 10-4-7 D.

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Page 5

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M113170

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00AM

320°F

9:30AM

0.00

0.00

=> 10/04/07

(X1)

Y6

190



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR 10-4-13

①

d.

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March 23, 2010 1:13:26 PM



Page 6

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ Sikaflex-291

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ Sikaflex-291

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M113545

10-4-13. ①

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March 23, 2010 1:13:26 PM



Page 7

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QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0.00

S 10/04/14

X

220

Packaging

0.00



Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

0.00

PPA 56 789

10/04/14

230

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

10/04/15
MF
10-4-15

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March 23, 2010 1:13:30 PM

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2580-1



205 Skidtube bent detail

Manufactured No 110 Each 2.0000 1.0000



Warehouse

Location

Main Warehouse

LG

54541

Loc Qty

Loc Code

Manufactured No

140 2
 124.0000 1.0000

124.0000 1.0000



10-3-30

D2576-3



Step (maching detail)

Warehouse

Location

Main Warehouse

LG

46661

52215

Loc Qty

Loc Code

124

77

47

BE 10/03/31

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March 23, 2010 1:13:30 PM

Page 2

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Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2579



Crossbolt Spacer

Manufactured No

140

Each

175.0000 20.0000



Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

LG

175

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

51525

4

53780

3

54543

18

56715

2

56818

26

Q 57052

20

BE 10/03/31

March 23, 2010 1:13:30 PM

Shop Packet Print

Page 2

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March 23, 2010 1:13:30 PM

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 139.0000 1.0000



Cap

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP6	1	
56613	1	
Main Warehouse		
ST026	138	
50513	1	
50770	1	
51539 ✓	37	
53791	99	

1 BR 10-4-13

AN3-5A Purchased No 200 Each 1,365.000 2.0000



Bolt

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST350	1365	
100188	188	
105057 ✓	1177	

2 BR 10-4-13.

March 23, 2010 1:13:30 PM

Shop Packet Print

Page 3

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March 23, 2010 1:13:30 PM

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Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L



Washer

Purchased

No

200

Each

3,009.000 2,0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

3009

101291

16

105793

49

110985 ✓

2944

ALS7-1032-130



Insert

Purchased

No

200

Each

986.0000 50.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

986

108606

52

111529

130

111779

34

112772

11

113238 ✓

759

2 BL 10-4-13.

50. BL 10-4-13.

March 23, 2010 1:13:31 PM

Shop Packet Print

Page 4

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,183.000 50.0000



BOLT



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST350	1183	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226 ✓	244	
113644	12	
113749	1	
114103	331	
114108	500	

AN960C10L



washer

Purchased No 200 Each 0.0000 50.0000



NAS 1149C0332R 113524

50 BR 10-4-13

March 23, 2010 1:13:31 PM

Shop Packet Print

Page 5

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Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-13 Manufactured No 200 Each 65.0000 1.0000
 Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	65	
45717	1	
50265	1	
5346 ✓	63	

D3566-5 Manufactured No 200 Each 27.0000 1.0000
 Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	3	
36113	1	
46186	1	
51260	1	
Main Warehouse		
FP015	13	
56829 ✓	13	
Main Warehouse		
FP19	11	
55335	11	

1 BR 10-4-13.

1 BR 10-4-13.

March 23, 2010 1:13:31 PM

Shop Packet Print

Page 6

Dart Aerospace Ltd

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Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3566-1



Gasket

Manufactured No

200

Each

41.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

19

46349

1

51218

1

51259

3

52512

3

54480

1

55011

1

56532

9

Main Warehouse

FP015

22

* 56825 ✓

22

D3564-11



Wearshoe

Manufactured

No

200

Each

5.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

5

45823

1

50112

1

56834 ✓

3

2 OK 10-4-13.

1 OK 10-4-13.

March 23, 2010 1:13:31 PM

Shop Packet Print

Page 7

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Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-13



Wearshoe

Manufactured No

200 Each 44.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 26

45409 2

46495 10

56285 ✓ 14

Main Warehouse

FP17 18

56533 18

1 PR 10-4-13.

D3564-9



Wearshoe

Manufactured No

200 Each 12.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 57260 12

44659 1

55334 11

1 PR 10-4-13.

March 23, 2010 1:13:31 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 23, 2010 1:13:31 PM

Work Order ID: 57137

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 23/03/2010

Required Date: 09/04/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5



Wearshoe

Manufactured No

200

Each

26.0000

1.0000



Warehouse
Location

Loc QtyLoc Code

OFFSHORE

2

FG

2

34806

Main Warehouse

24

FP

1

45824

11

55024 ✓

12

55333

200

Each

412.0000

16.0000



D2594-3



O-Ring, 205 Skidtube

Manufactured No

Warehouse
Location

Loc QtyLoc Code

Main Warehouse

412

FP

27

51613

13

52562

372

55546 ✓

1 BR 10-4-13.

16 BR 10-4-13.

Shop Packet Print

March 23, 2010 1:13:31 PM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March 23, 2010 1:13:31 PM

Page 10

Work Order ID: 57137



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 23/03/2010

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Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
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IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

513.0000 16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP	513
42221	16
42807	92
43884	3
46435	2
51527	9
51757	6
54008	1
54643	15
55002 ✓	369

16 10-4-13

March 23, 2010 1:13:31 PM

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Page 10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57137

2010-3-23

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-06-28-1

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular base plate with the following specifications:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to two small circular holes.
- #0.208**: Dimension for the diameter of the mounting holes.
- AN3-5A BOLT (1)**: Points to a bolt in the center.
- AN960/D10L WASHER (1) (2 PLACES)**: Points to two rectangular washers on either side of the central bolt.
- D2855 CAP**: Points to the central bolt.
- SEAL WITH SIKAFLEX-241/-291**: Points to the outer edge of the plate.
- 0.40**: Dimension for the thickness of the plate.

5

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO 80.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible]

Technical drawing of a horizontal curve with two circular arcs. The left arc has a radius of 13.4 and a central angle of 4 degrees. The right arc has a radius of 32.0 ± 1.0 and a central angle of 4 degrees. The distance between the hole and the tangent point for the left arc is 1.0, and for the right arc is 1.0. The total length of the curve is 20.0. The offset from the centerline to the hole is 1.4. The drawing is labeled '11'.

[illegible]

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APPROVED

1. A

DART AEROSPACE LTD.
MISSISSAUGA, ONTARIO, CANADA

REV. D

SHEET 2 OF 3

SCALE

205 SKIDTUBE ASSEMBLY

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07 Dec 28

Diagram illustrating the underside of the D2576-3 step, showing the locations for grinding flush and the location ridge on the underside of the D2576.

Labels in the diagram include:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Technical drawing of a circular component with a central hole and a bolt. The drawing includes labels for various parts and dimensions. A central bolt is labeled "AN3-SA BOLT (1)" and "AN960J10L WASHER (1) (2 PLACES)". The bolt is secured with a "D2855 CAP". The central hole is labeled "DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)". The outer edge of the component is labeled "SEAL WITH SIKAFLEX-241/-291". A dimension line indicates a distance of "0.40" from the center to the outer edge. A note "SEE NOTE 1)" points to the bolt area.

D2579 SPACER

WEB (REF)

130 (REF)
0 PLACES

AFTER PERFO

1. CHA
2. INS
3. WEI
4. C'B

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50
DISTANCE TO AFT END
OF D2500 WEB

3
7

1.750 1.750

Ø0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

91.500

38.0

190.0
(D2500-1)

REFER TO DETAIL E

Figure 1: Typical Bridge Deck Drilling Detail. This technical drawing shows a cross-section of a bridge deck with various dimensions and callouts. Key dimensions include a total width of 51.340, a reference width of 5.338 (REF), a hole diameter of 5.985, a hole spacing of 39.580, a hole diameter of 5.915, a hole spacing of 3.630 (REF), a hole diameter of 5.908 (8 PLACES), a hole spacing of 20.0, a hole diameter of 5.640, a hole spacing of 1.0, a hole diameter of 1.0, a hole spacing of 1.0, and a hole diameter of 1.0. The drawing also shows a 1.4 inch dimension, a 1.0 inch dimension, a 1.0 inch dimension, and a 32.0 ± 1.0 inch dimension. Callouts include '4' and '11'.

0.5

1.5

1.5

H

REFER TO DETAIL G

NO C'BORE
NO PLUG

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP
TO 0.5 ABOVE BOTTOM EDGE

1.5

1.5

1.5

8

P

H

NO C'BORE
NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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211

10

CHECKED

1

DATE _____

07.02.2

07.02.2

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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1

DART AEROSPACE LTD.
HAMMILLSBURY, ONTARIO, CANADA

DRAWING NO.	
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D2580

TITLE

225

205 \$

25

RE

SHEET 3 OF 3

ASSEMBLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 227

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 56925
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Paul Smith Date of Test Coupon 10-03-19

Welder Barday Elliott Date of Test Coupon 10-03-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

